

**USDA, AMS,
Livestock and Seed Program**

APPROVED

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**ITEM DESCRIPTION AND
CHECKLIST OF REQUIREMENTS (IDCR) FOR
FULLY COOKED BONELESS CURED HAM,
PRODUCTS**

I. ITEM DESCRIPTION

- Items –
1. **Ham, Cured, Boneless, Fully-Cooked, Water Added** – For product codes A693 and A694, four 10-pound hams will be snugly packed into shipping containers to a net weight of 40 pounds. For product code A669, twelve 3-pound hams will be snugly packed into a shipping container to a net weight of 36 pounds. The bulk packaged hams will be round or flat (pressed) in shape, and have a diameter of 4.0 to 4.5 inches.
 2. **Ham, Cured, Boneless, Fully-Cooked, Water Added, Thinly Sliced.** – Thinly sliced (not shaved) ham (A726) shall be shingle layered and packaged. Eight 5-pound packages will be snugly packed into shipping containers to a net weight of 40 pounds. The full intact slices shall be round, square, or oval shaped, and have a diameter of 4.0 to 4.5 inches.

The above items shall be 97% fat free (3% fat), minimum Protein Fat Free (PFF) value of 17%, and have a whole muscle appearance (not ground or chopped), uniform color (slightly two tone color is permissible), no spongy (porous texture) appearance (after thawing of frozen ham).

3. **Ham, Cured, Fully-Cooked, Diced** – The product shall be 97% fat free and have a minimum PFF value of 15% and may be made from ham and water product. This item (A727) is recommended for use as a topping for pizza, salads, and as a component for soups, stews, and casseroles. Eight 5-pound packages will be snugly packed into shipping containers to a net weight of 40 pounds. The dices shall be ¼ inch and may be made from ground or chopped and formed ham.

II. CHECKLIST OF REQUIREMENTS

All items must be produced in accordance with Food Safety and Inspection Service (FSIS) regulations and the checklist of requirements.

A. MATERIALS

The contractor's technical proposal must include procedures to address conformance with the following material requirements.

1. MEAT COMPONENT

Pork will be the only meat component allowed.

- a) Domestic Origin – All hams will originate from U.S. produced hogs as defined in this announcement.
- b) Harvesting (Slaughtering) – Hogs will be harvested in facilities that comply with the following requirements:
 - (1) Humane Handling – All hogs will be humanely handled in accordance with all applicable FSIS regulations, directives, and notices.

- (2) Non-Ambulatory Disabled Hogs – Meat from carcasses of non-ambulatory disabled hogs will not be included.
- c) Boneless Pork Legs – Hams will be derived from boneless pork legs that comply with the following requirements:
 - (1) Handling – All boneless pork legs must be maintained in excellent condition. The contractor's technical proposal shall include detailed production scheduling with time and temperature controls necessary to maintain excellent condition of the boneless pork legs.
 - (2) Fresh Chilled Only – Meat will be derived from fresh chilled boneless pork legs. Previously frozen boneless pork legs cannot be used.
 - (3) Uniform Color – To the extent possible, pork leg muscles should be sorted for color uniformity.
 - (4) Lean Quality – The pork leg muscles must not exhibit any evidence of pale, soft, and/or exudative conditions.
 - (5) Shanks and Inner Shanks – If used, shanks and inner shanks must be ground, emulsified, or otherwise reduced in size.
 - (6) Objectionable Materials – Pork legs will be free of bones, cartilages, skins, spinal cord, and foreign materials.
 - (7) Ground Meat – Pork leg trimmings (including shank meat) that is ground, emulsified, or otherwise reduced in size cannot exceed 7% of the meat component.
- d) Mechanical Separation – Meat that is mechanically separated from bone with automatic deboning systems, advanced lean (meat) recovery (AMR) systems, or powered knives will not be allowed.

2. NON-MEAT COMPONENTS

All non-meat components will be listed in the ingredient statements.

- a) Product Formula – The production formula must include water, dextrose, salt, sodium phosphate and sodium nitrite. Sodium erythorbate, and/or sodium ascorbate, may be used.
- b) Ingredient Limitations – The ingredients in the product formula must comply with the amount as listed:
 - (1) Dextrose – 3%
 - (2) Salt – 2.5%
 - (3) Sodium Phosphate – No more than 0.5%
- c) Binder Agent – Binder agents such as carrageenan, modified food starch, and isolated soy protein may be used.

B. PROCESSING

1. PROCESSING DATE

Hams will be processed no more than 60 days prior to shipment.

2. CASING DIAMETER

All hams will be stuffed and processed within high oxygen and high moisture barrier poly "cook-n-ship" casings with a diameter of 4.0 to 4.5 inches. Ham then may be pressed.

3. PRODUCT COOKING

Ham will be heat processed (cooked) to reach an internal temperature of not less than 155°F.

4. METAL DETECTION

All hams must be free of metal contamination. Detection of stainless steel, ferrous, and non-ferrous (e.g., lead, copper, and aluminum) metals is required. The equipment, location, detection procedure, sensitivity levels, frequency of equipment validation, and corrective action procedures will be identified and described.

C. FINISHED PRODUCT LIMITATIONS

Fat and protein-fat-free label declarations shall comply with FSIS labeling regulations.

1. FAT

The contractor will target production to maintain a process average for fat content to be 3.0 percent or less. The contractor will use a Statistical Process Control (SPC) program to analyze fat test results. The SPC Upper Specification Limit (USL) is 3.6 percent fat. The average test results of each production lot exceeding the USL will not be allowed delivery to USDA. For the purpose of this section, a lot cannot exceed one day's production.

2. PROTEIN FAT FREE (PFF)

The contractor will target their production to maintain the PFF values as specified with the item description.

3. MICROBIAL

Contractor must have a documented plan to comply with the latest FSIS *Salmonella* and *Listeria monocytogenes* requirements for ready-to-eat foods. Product tested positive for any pathogen will not be allowed as rework or delivery to USDA.

4. PHYSICAL CHARACTERISTICS

Since one or more freeze/thaw cycles will cause moisture loss and affect quality, hams shall not appear spongy or porous in texture after freezing and thawing. Diced hams will be processed to preclude 'clumping' so that it is easily removed from bags by the end user without thawing.

D. STATE OF REFRIGERATION

Hams must comply with the following holding time and temperature requirements:

1. HOLDING TIME

For Frozen Ham Products – After processing, ham destined for freezing will be refrigerated for a minimum of 24 hours. The diced ham will be individually quick frozen (IQF) or processed in a manner to prevent it from sticking together (clumping) after freezing.

2. HOLDING TEMPERATURE

- a) Frozen Hams (A693, A669, A726, A727) – Hams destined for freezing will have an internal temperature not to exceed 40° F prior to placement in the freezer.
- b) Chilled Hams (A694) – Chilled hams will be maintained at a temperature of not less than 28°F (2.2°C) or higher than 40°F (4.4°C).

3. 72 HOURS TEMPERATURE

Frozen hams must be 0° F or below within 72 hours after placement into the freezer.

E. PREPARATION FOR DELIVERY

1. PACKAGING

- a) Package – All bulk packaged hams will be stuffed and processed within poly "cook-n-ship" high oxygen and high moisture barrier casings. Sliced, shingled layered hams and diced hams will be packaged into bags or thermoformed packaging and vacuum sealed. All packages will be closed by heat seal or metal clips.
- b) Package Net Weight –
 - (1) Bulk packed frozen ham will be packaged into casings to a net weight of 3 or 10 pounds (as specified by the purchaser). Chilled ham will be packaged in 10 pound casings, only.
 - (2) Sliced and diced hams will be vacuum bagged or thermoformed vacuum packaged to a net weight of 5 pounds.

2. PACKING

- a) 3-Pound Ham – Twelve, 3-pound hams will be snugly packed into a new shipping container to a net weight of 36 pounds.
- b) 10-Pound Ham – Four, 10-pound hams will be snugly packed into a new shipping container to a net weight of 40 pounds.
- c) Sliced or Diced Ham – Eight 5-pound packages will be snugly packed into a new shipping container to a net weight of 40 pounds. Packaged diced ham shall have no 'clumping' so that it is easily removed from bag by end user without thawing.

3. LABELING

The shipping containers will be in compliance with the National Motor Freight Classification, or the Uniform Freight Classification, as applicable. Both primary (packaging material) and shipping containers will be labeled to include all information required by FSIS regulations.

- a) 10-Pound Ham, 5-Pound Sliced and Diced Hams Primary Container Labels (Casings or package) – Each primary container is required to have a traceability code that is traced back to establishment number, production lot, and date.
- b) 3-Pound Ham Primary Container Label – Each primary container will contain the following information:
 - (1) A traceability code that is traced back to establishment number, production lot, and date.
 - (2) A "Best-If-Used-By" date that is 180 calendar days from the date of production.
 - (3) Nutrition facts panel based on actual nutritional analysis of the product.
- c) Shipping Container Label – Shipping containers will contain the following information:
 - (1) USDA shield at least 2 inches high and appearing on the top of the container or on the principle display panel.
 - (2) Appropriate contract number.



- (3) A traceability code that is traced back to establishment number, production lot, and date.
- (4) Nutrition facts panel based on actual nutritional analysis of the product.
- (5) 10-Pound Ham, 5-Pound Sliced and Diced Hams shipping containers shall have the statement “for institutional use only”.
- (6) The appropriate product codes listed in the table below.

Product Code	
Item	Code
10 lbs frozen ham	A693
10 lbs chilled ham	A694
3 lbs frozen ham	A669
5 lbs sliced, frozen ham	A726
5 lbs diced, frozen ham	A727

All labeling illustrations must be provided.

4. PALLETIZED UNIT LOADS

All shipping containers shall be stacked on new or well-maintained pallets and secured with shrink wrap plastic.

F. DELIVERY UNIT

The delivery units for each of the following respective product codes are as follow:

1. PRODUCT CODES A693, A694, A726, A727

Each delivery will consist of 1,000 shipping containers with a net weight of 40,000 pounds.

2. PRODUCT CODE A669

Each delivery will consist of 1,000 shipping containers with a net weight of 36,000 pounds.

G. DELIVERED PRODUCT

1. SIZE AND STYLE OF CONTAINER

Only one size and style of primary (casings) and shipping containers may be offered in an individual shipping unit.

2. TEMPERATURE

- a) Chilled Ham Temperature – Chilled ham will be delivered at a temperature of not less than 28°F (2.2°C) or higher than 40°F (4.4°C).
- b) Frozen Ham Temperature – All products will be frozen and will not exceed 0° F at the time of shipment and delivery.

3. SEALING

All products must be delivered to AMS destinations under seal in accordance with Section I.C. of this Announcement.

H. WARRANTY AND COMPLAINT RESOLUTION

1. WARRANTY

The contractor will guarantee that the product complies with all contractual requirements.

2. COMPLAINT RESOLUTION

The contractor's technical proposal must provide the steps taken to resolve complaints received on the product i.e, point of contact, cause and effect analysis, corrective and preventative actions taken, and product replacement.

I. NON-CONFORMING PRODUCT

The contractor must include a plan to assure that non-conforming product is not delivered under USDA contracts. The plan must address 1) control and segregation of non-conforming product, 2) removal of any USDA markings, and 3) disposition of non-conforming product.